

678,022 BLUE

Dart Aerospace Ltd.

Date: Tuesday, 14/10/2008 1:16:06 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: 206L/407 STEP ASSY, RH	
Job Number	: 42584A				Part Number	: D2724042	
Estimate Number	: 11703				Drawing Number	: D2724 REV C	
P.O. Number	:				Project Number	:	
This Issue	: 14/10/2008 S.O. No. :				Drawing Revision	: C	
Prsht Rev.	: NC				Material	:	
First Issue	: / / Type : LARGE FAB ASSY				Due Date	: 04/11/2008 Qty: 2 Um: Each	
Previous Run	: 39838A						
Written By	:						
Checked & Approved By	: <u>Jul 08. 10. 14</u>						
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Qty Part # Description Batch:	<u>B39316</u>
		Check Material for any Dents or Defects	
			BAD 08/10/16 2
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		Cut D2724-2 using D2622 extrusion as per Dwg D2724	
		Deburr and bevel ends for welding	
3.0	D2734	Step End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		206 Step Endplate	
		Pick:	
		Qty Part Number Description Batch	<u>B39179</u>
		2 D2734 End Cap	
4.0	D34581	Step Mounting Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	<u>B36408</u>
		2 D3458-1 Plate	
			SP 08.10.16 2X
			SP 08.10.16 2X

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 1:16:06 PM
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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 42584A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

B36409 SP

08.10.16 (2X)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch:

M1092B

M104855

Grind end cap welds flush

SP 08.10.28

SP 08.10.28

(2X)

7.0 QC9

VISUAL WELDING INSPECTION



(2X)

Comment: VISUAL WELDING INSPECTION

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08/10/30 (2X)

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(2X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SP

08-10-31

(2X)

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SP 08/10/31 (2X)

Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SP 08-11-03

(2X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 1:16:06 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/407 STEP ASSY, RH

Job Number: 42584A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remainig end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: 11104855

SP 08.11.03 (2X)

Grind end plate flush.

SAB 08.11.03 (2)

12.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1108.11.03 (2)

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

108.11.03 (2)

RH's.

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

M-f

08/11/03

15.0 SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B109450

-SPRAY PAINT DELFLEET BLUE

B105918

-CLEAR DELFLEET

B109816

M 08 09 09 (2)

16.0 QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

RT 08-11-10

17.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M109219

Ex 08/10/10 (2)

Comment: Wing Walk as per Dwg D2724 and QSI 00 54.4

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pctg 11 (2)

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1

PACKAGING RESOURCE #1



~~34~~

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 42584

81,11

34

20.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/12 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/11/12

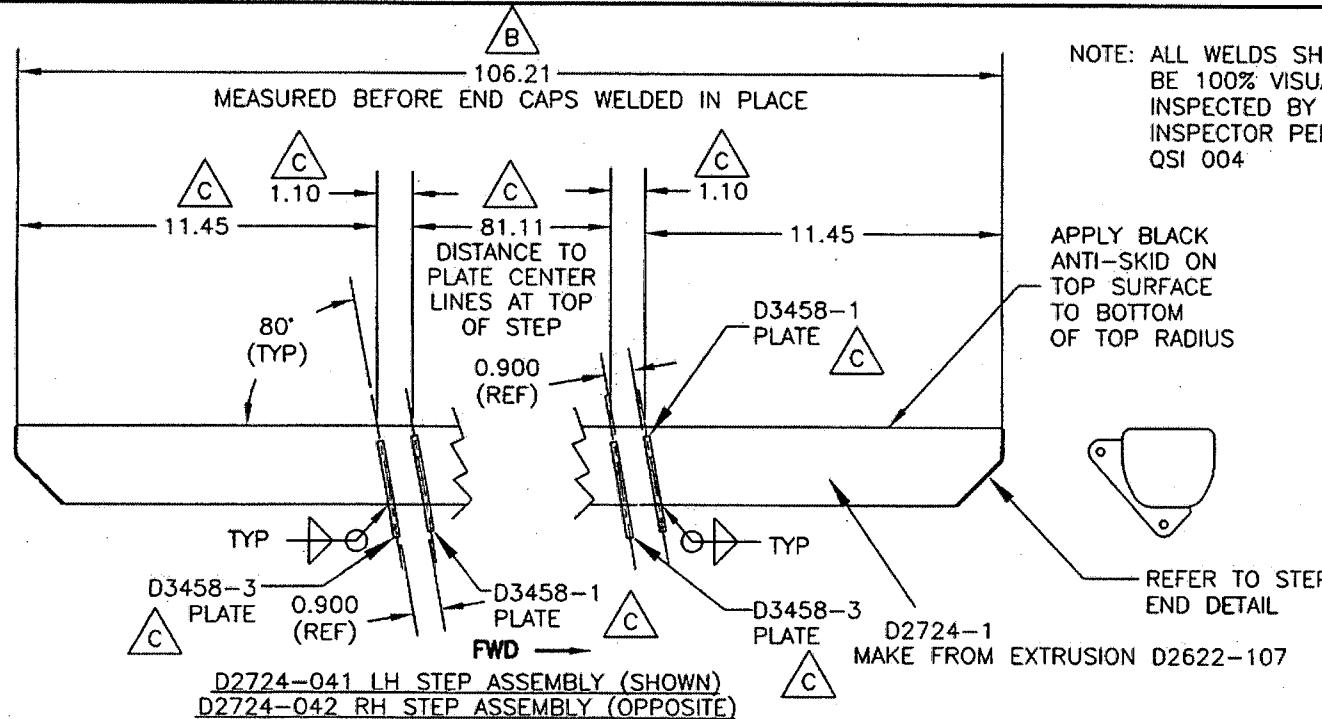
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

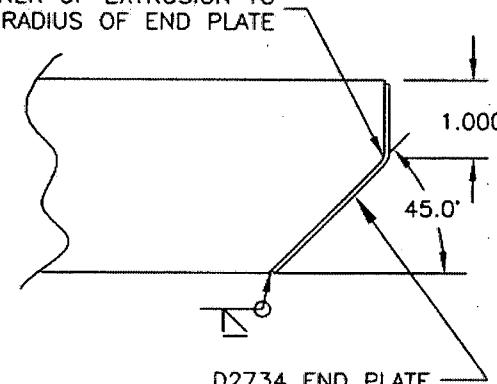
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
D2724-041/-042 STEP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING

NOT TO SCALE

B

TYPICAL STEP END DETAIL



DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. C
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2724	SHEET 1 OF 1
DATE 05.09.19	TITLE 206L/407 STEP ASSEMBLY	SCALE NTS	
A	97.12.04 NEW ISSUE		
B	98.10.19 UPDATED WELD DETAIL REVISED TOLERANCES		
C	05.09.19 RE-DESIGN, ADD D3458-1/-3		